

Date: Monday, 3/13/2006 7:29:48 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 3" SKID EXTRUSION (NO OUTER RIDGE)
<b>Job Number</b> : 26205	
<b>Estimate Number</b> : 10054	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D26003120
<b>This Issue</b> : 3/13/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2600 REV D1
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : D1
<b>Previous Run</b> : 23201	<b>Material</b> : N/A
<b>Written By</b> : <u>See Comment Below</u>	<b>Due Date</b> : 4/5/2006
<b>Checked &amp; Approved By</b> : <u>06.03.13</u>	<b>Qty:</b> <u>78</u> <b>Um:</b> Each
<b>Comment</b> : Est. D: 02.09.10 Added DSK 066 KJ/RF	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 00000825AP 06/03/20

- a) Extrude as per Dwg D2600
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 40 ksi
- e) Minimum elongation = 8%
- f) Order at 120" long
- g) Bon L Canada Inc. tool # 897122
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

2.0	D26003120P	Extrusion Round 3" 350
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 140.0000 Each(s)  
 Extrusion Round 3" 350

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage  
 Ensure material certification is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimension per Dwg D2600  
 Check Pull test per Dwg D2600 for compliance page attached  
 Check hardness with Webster tester

P. 4/4/3 7806.04.0478

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: PL Date: 04/01/05  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 3/13/2006 7:29:49 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 3" SKID EXTRUSION (NO OUTER RIDGE)

Job Number: 26205

Part Number: D26003120

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



06-04-04

78

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

6.0

DC

DOCUMENT CONTROL



78

Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/05

Job Completion



u 06-04-05

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS & DIE NUMBERS <i>+GP</i>	

RELEASED  
98.08.25 DS

### GENERAL NOTES

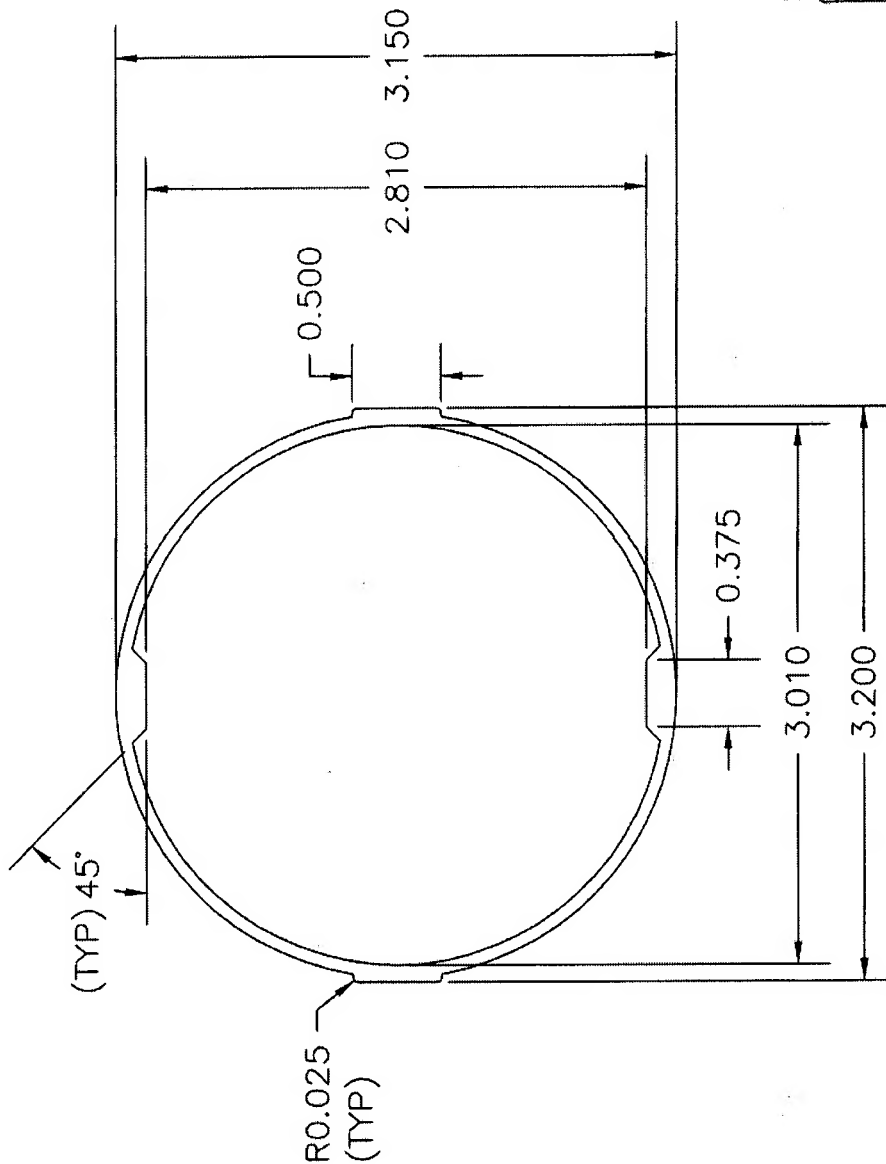
1. MATERIAL: 6061-T6 (QQ-A-200/8)  
  
MINIMUM YIELD TENSILE STRENGTH = 35 ksi  
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi  
MINIMUM ELONGATION = 8 %  
  
A SAMPLE FROM EACH BATCH WILL BE PULL TESTED  
TO ASTM STANDARD B221 BY AN APPROVED TESTING  
FACILITY TO ENSURE THAT THE BATCH MEETS THE  
ABOVE MINIMUM MECHANICAL PROPERTIES.
2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE  
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

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CHECKED <i>KE</i>	APPROVED <i>DD</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

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98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870

OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

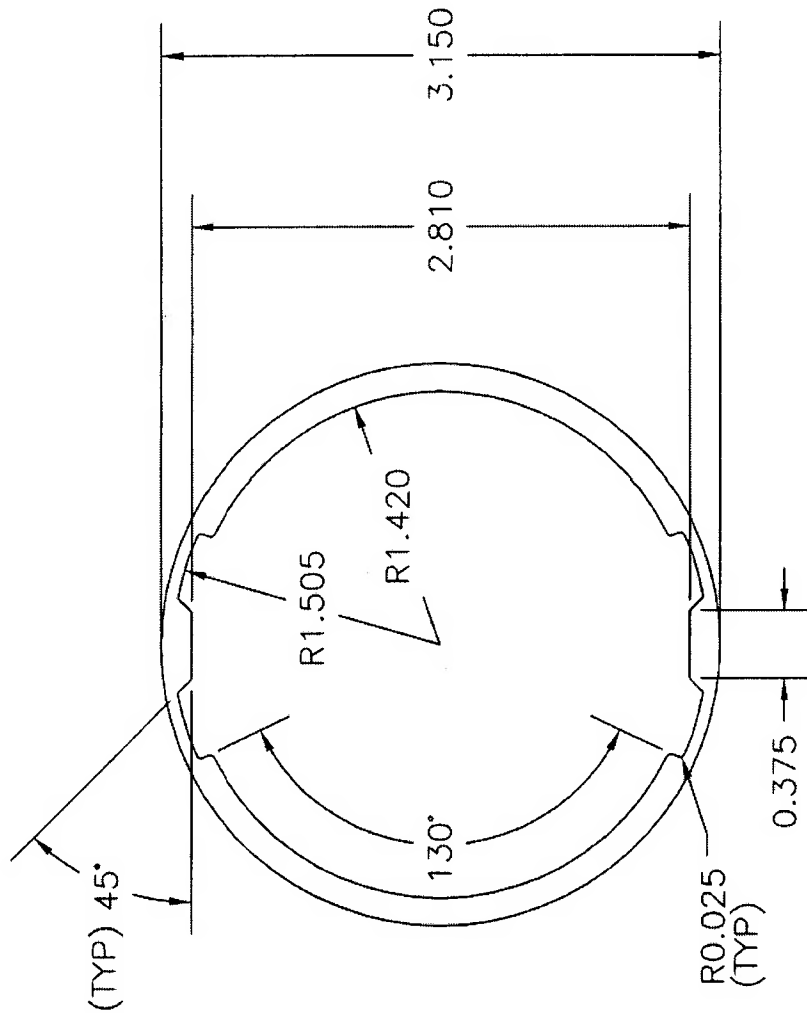


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. D SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

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98.8.25 DS



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-1720 IS 1720" LONG)



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WORK ORDER

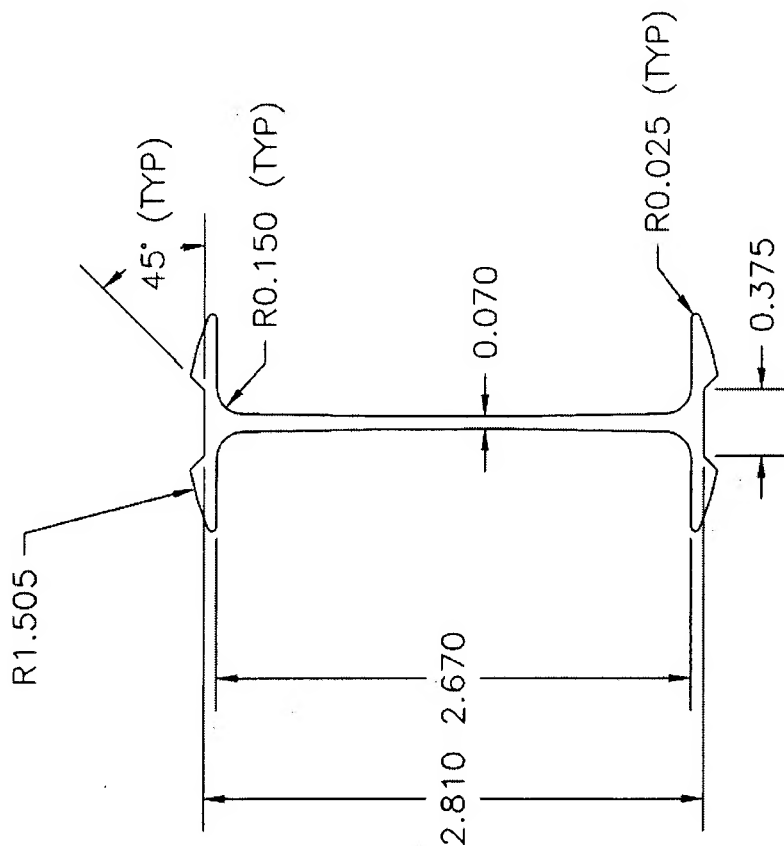
NO. 26205





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DATE 98.08.20	TITLE EXTRUSION		SCALE 1:1

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98.8.25. DS



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871  
PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-5-108 IS 108" LONG)



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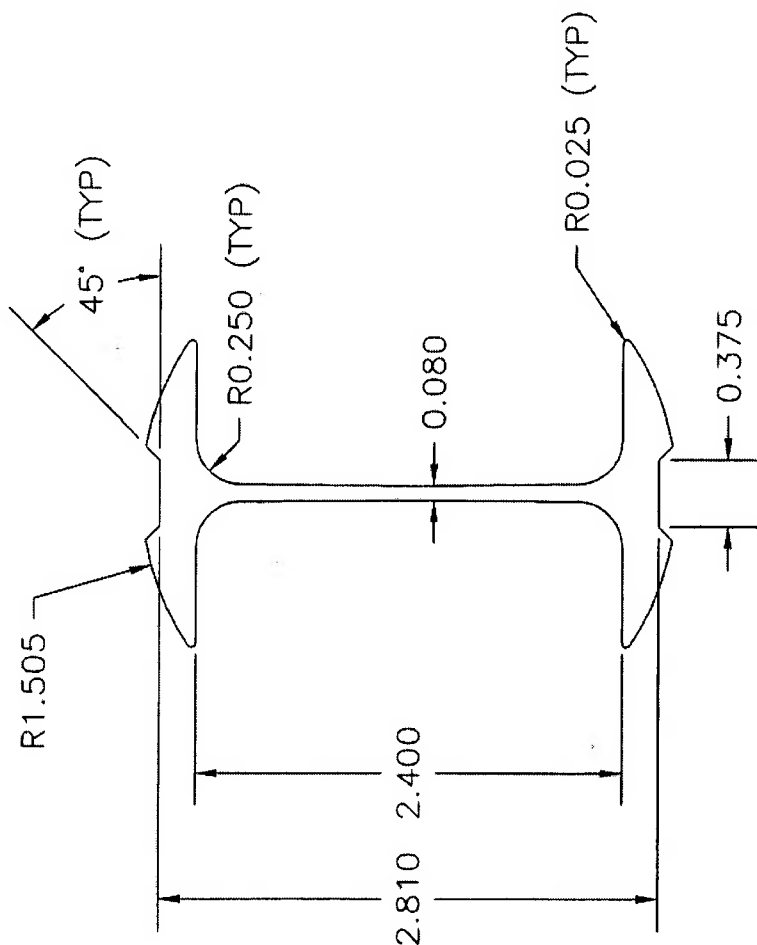
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WORK ORDER  
NO. 26205



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CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. 0 SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED  
98.8.25 DS



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872  
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES  
(EG. D2600-7-125 IS 125" LONG)



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# CERTIFICATE OF COMPLIANCE

## BON L CANADA INC

1850 CLEMENTS ROAD  
PICKERING, ON L1W 3R8

Cert Date	Cert No	Sales Order	Page
04/02/06	137149	14055	1
Cust PO	B/I No	Lot	Date
825	00299028	14055010	4/02/06

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Item No	Part No	Item Description	Cust Part
1.000	DAA-897122-1	120" Mill 6061 T6	D2600-3-120
Gross Weight	566 KGS		
Net Qty	558 KG	78 PC	238 M 2 PKG
Specification	Die Desc		
AMS-QQ-A-200/8 & ASTM B221-00			

### Mechanical Tests:

Test No.	Tensile MPA / KSI	Yield MPA / KSI	%Elongation	Conductivity	Bend/ Drift HREW
1	311.0 / 45.1	291.8 / 42.3	11.3	.0	93

### Chemical Limits:

	SI	FE	CU	MN	MG	CR	ZN	TI	OTHER
MIN:	.40	.00	.15	.00	.80	.04	.00	.00	EA: .05
MAX:	.80	.70	.40	.15	1.20	.35	.25	.15	TOT: .15

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

Conchita Ko, QA Manager Signed for Bon L Canada

*Conchita Ko*

PJ 825